

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018377**Date Inspected:** 25-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Visual Inspection Testing (VT) on lift-4 tower shafts for fit-lug plate cut-outs

This QA inspector performed VT on lift-4 tower shafts for fit-lug plate cut-outs at 119 M elevation on North, East, West and South shafts. It has been observed that ZPMC personnel have not yet completed the repair work as per the TC-RFI-ZPM-0166R0 on North shaft. The member is identified as TOWER Component.

For further details please see the below attached pictures:

BAY#10**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Repair welding of weld joint # 43 located on Bike Path BK004A1 – 032. Welder is identified as 040302. ZPMC

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Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Weld joint # 18 located on Bike Path bottom cover plate BK004A2 – 029. Welder is identified as 040367. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F.

Weld joint # 73 located on Bike Path BK008A7 – 001. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Repair welding of weld joint # 43 located on Bike Path BK004A1 – 032. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Weld joint # 25 located on Bike Path BK008A3 – 001. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY#11

This QA Inspector observed the following work in progress

Sub-merged Arc Welding (SAW):

Weld joint # 01 located on Lift-6 Tower Head component SSD1 – DPSA6 – 5. Welder is identified as 056975. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

Fluxcored Arc Welding (FCAW):

Weld joint # 05 located on Lift-6 Tower Head ESD1 – FDSA6 – 2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

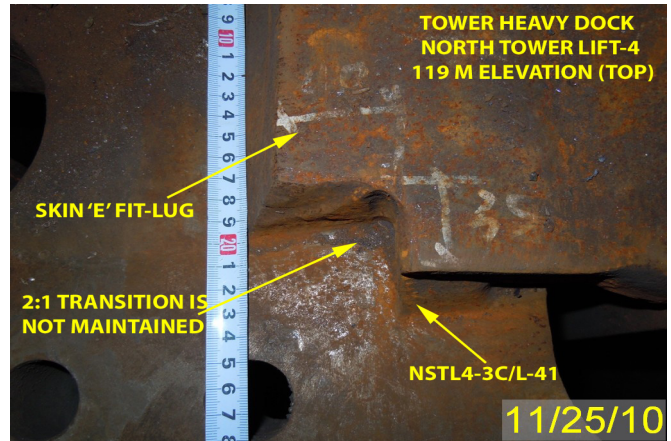
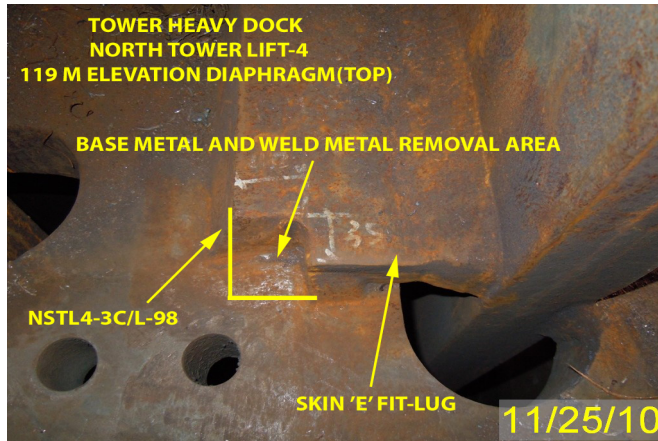
Weld joint # 02 located on Lift-6 Tower Head WSD1 – FDSA6 – 4. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 01 located on Lift-6 Tower Head component SSD1 – DPSA6 – 5. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U3c – F – 2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer